

Work Order ID 51650

August 27, 2009 8:39:34 AM

Page 1

Item ID: D3610-041

Revision ID: A

Item Name: Bracket

Start Date: 8/27/09

Start Qty: 8.00

Required Date: 9/11/09

Req'd Qty: 8.00

Reference:

Approvals:

Process Plan:

Date:

Tooling:

Date:

Run

Start

QC:

Date:

SPC (Y/N):

Date:

Stop

Sequence ID/
Work Center ID

Operation
Description

Set Up/
Run Hours

Draw
Number

Draw
Rev.

Plan
Code

Accept
Qty

Reject
Qty

Reject
Number

Insp.
Stamp

Draw Nbr

Revision Nbr

D3610

Rev A

100



Bandsaw

Jeaspa Bandsaw

BAND SAW

Memo

Cut blank 6.600 " long

0.00

0.00

110



HAAS 1

HAAS CNC vertical machine #1

HAAS CNC VERTICAL MACHINING #1

Memo

1- Mill as per Folio FA692 Rev: AA & Dwg D3610 Rev: A 12-Deburr per dwg D3610

0.00

0.00

120



QC

Quality Control

QC2- Inspect parts off machine FAI/FAIB

Memo

0.00

0.00

Accept



Setup Start



Stop



Cust Item ID:

Customer:



mt 09/08/31

mt 09/09/03

mt 09/09/03

RTO

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: D3610-041 PAR #: _____ Fault Category: Machined Parts NCR: Yes No DQA: [Signature] Date: 05-05-25
 Resolution: Scrap Disposition: Scrap QA: N/C Closed: [Signature] Date: 08-05-25

NCR: <u>51650</u>		WORK ORDER NON-CONFORMANCE (NCR)						
DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Chief Eng	Approval QC Inspector
			Initial Chief Eng	Action Description Chief Eng	Sign & Date			
<u>31/01/03</u>	<u>110</u>	Thickness .250 is too small because operator put offset .025 instead of .0025. R.C. operator error	<u>[Signature]</u> RESIM2	Scrap & destroy Replace Qty 1 <u>M112347</u>	<u>mmf</u> <u>01/09/03</u>	<u>mmf</u> <u>01/09/03</u>	<u>[Signature]</u> RESIM2	<u>[Signature]</u> 05/08/03

NOTE: Date & initial all entries

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Item ID: D3610-041

Revision ID: A

Item Name: Bracket

Start Date: 8/27/09 Start Qty: 8.00

Required Date: 9/11/09 Req'd Qty: 8.00

Reference:

Accept



Setup Start



Stop



Cust Item ID:

Customer:

Approvals:

Process Plan:

Date:

Tooling:

Date:

Run Start



QC:

Date:

SPC (Y/N):

Date:

Stop



Sequence ID/
Work Center ID

Operation
Description

Set Up/
Run Hours

Draw
Number

Draw
Rev.

Plan
Code

Accept
Qty

Reject
Qty

Reject
Number

Insp.
Stamp

130



QC

Quality Control

QC8- Inspect parts - second check

0.00

Memo

0.00

B.A 09/09/04

8

1

140



Small Fab

Small Fab

Small Fab

Memo

I-C'SINK AS PER DWG D3610

0.00

0.00

09/09/11



150



QC

Quality Control

QC5- Inspect part completeness to step on W/O

0.00

Memo

0.00

2) 09/09/11



1

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: _____ PAR #: _____ Fault Category: _____ NCR: Yes No DQA: _____ Date: _____

Resolution: _____ Disposition: _____ QA: N/C Closed: _____ Date: _____

NCR:		WORK ORDER NON-CONFORMANCE (NCR)						
DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Chief Eng	Approval QC Inspector
			Initial Chief Eng	Action Description Chief Eng	Sign & Date			

NOTE: Date & initial all entries

Work Order ID 51650

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Item ID: D3610-041

Accept



Setup Start



Revision ID: A

Stop



Item Name: Bracket

Start Date: 8/27/09

Start Qty: 8.00



Cust Item ID:

Required Date: 9/11/09

Req'd Qty: 8.00



Customer:

Reference:

Run Start



Approvals:

Process Plan:

Date:

Tooling:

Date:

Stop



QC:

Date:

SPC (Y/N):

Date:

Sequence ID/
Work Center ID

Operation
Description

Set Up/
Run Hours

Draw
Number

Draw
Rev.

Plan
Code

Accept
Qty

Reject
Qty

Reject
Number

Insp.
Stamp

160



Powdercoat

Powder Coating

Grey Sandtex(Ref:4.3.5.6) per QSI005 4.3

0.00

Memo

START TIME:

9:00AM

FINISH TIME:

OVEN TEMPERATURE:

320°F

⇒ JH 09/09/14 (X8) Ø

170



QC

Quality Control

QC3- Inspect Part Finish

0.00

Memo

BF 09-09-14 (8)

180



Small Fab

Small Fab

Small Fab

Memo

Rivet Nut Plate as per Dwg D3610

0.00

0.00

EP 09/09/22 (8)

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: _____ PAR #: _____ Fault Category: _____ NCR: Yes No DQA: _____ Date: _____

Resolution: _____ Disposition: _____ QA: N/C Closed: _____ Date: _____

NCR:		WORK ORDER NON-CONFORMANCE (NCR)						
DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Chief Eng	Approval QC Inspector
			Initial Chief Eng	Action Description Chief Eng	Sign & Date			

NOTE: Date & initial all entries

Work Order ID 51650

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Item ID: D3610-041

Accept



Setup Start



Revision ID: A

Stop



Item Name: Bracket

Start Date: 8/27/09

Start Qty: 8.00



Cust Item ID:

Required Date: 9/11/09

Req'd Qty: 8.00



Customer:

Reference:

Approvals:

Process Plan:

Date:

Tooling:

Date:

Run Start



QC:

Date:

SPC (Y/N):

Date:

Stop



Sequence ID/
Work Center ID

Operation
Description

Set Up/
Run Hours

Draw
Number

Draw
Rev.

Plan
Code

Accept
Qty

Reject
Qty

Reject
Number

Insp.
Stamp

190



QC

Quality Control

QC5- Inspect part completeness to step on W/O

0.00

0.00

Memo

8/02/09/22

(x8)

/

200



Packaging

Packaging

Identify as per dwg & Stock Location: 244A

0.00

0.00

Memo

9/9/09

(2x)

sf

210



QC

Quality Control

QC21- Final Inspection - Work Order Release

0.00

0.00

Memo

09/09/23

mf 09-09-23

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: _____ PAR #: _____ Fault Category: _____ NCR: Yes No DQA: _____ Date: _____

Resolution: _____ Disposition: _____ QA: N/C Closed: _____ Date: _____

NCR:		WORK ORDER NON-CONFORMANCE (NCR)						
DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Chief Eng	Approval QC Inspector
			Initial Chief Eng	Action Description Chief Eng	Sign & Date			

NOTE: Date & initial all entries

Picklist Print

August 27, 2009 8:39:34 AM

Page 1

Work Order ID: 51650

Parent Item: D3610-041RevA

Parent Item Name: Bracket

Comments:

Start Date: 8/27/09

Required Date: 9/11/09

Start Qty: 8.00

Required Qty: 8.00

Component Item ID/ Item Name	Replacement Item ID	Mfg/ Purch	Bin Item	Primary Location	Last Location	Route Seq ID	Unit of Measure	Qty on Hand	Remaining Qty To Pick	Qty Issued	Date Issued	Status
M4140N- B1.500X1.5000		Purchased	No			100	f	24.0166	4.6200			
4140 Steel Bar 1.50 x 1.50												

Warehouse Loc Qty Loc Code
Location

Main Warehouse

MAT

24.0166

112397

24.0166

MS20426AD3-4

Purchased

No

110

Each

8,257.000

16.0000



RIVET

Warehouse Loc Qty Loc Code
Location

Main Warehouse

ST

8257

104374

4257

110398

4000

MS21075L3

Purchased

No

180

Each

123.0000

8.0000



Nutplate

Warehouse Loc Qty Loc Code
Location

Main Warehouse

ST

123

109068

12

109371

39

110704

37

111477

15

112314

20

4.62" wh 09/08/31

EP 09/09/22

16

EP 09/09/22

M112690

800

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: _____ PAR #: _____ Fault Category: _____ NCR: Yes No DQA: _____ Date: _____

Resolution: _____ Disposition: _____ QA: N/C Closed: _____ Date: _____

NCR:		WORK ORDER NON-CONFORMANCE (NCR)						
DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Chief Eng	Approval QC Inspector
			Initial Chief Eng	Action Description Chief Eng	Sign & Date			

NOTE: Date & initial all entries

DART AEROSPACE LTD		Work Order:	51650
Description: Plate		Part Number:	D3610-1
Inspection Dwg: D3610 Rev: A		Page 1 of 1	

FIRST ARTICLE INSPECTION CHECKLIST

☒ First Article ☐ Prototype

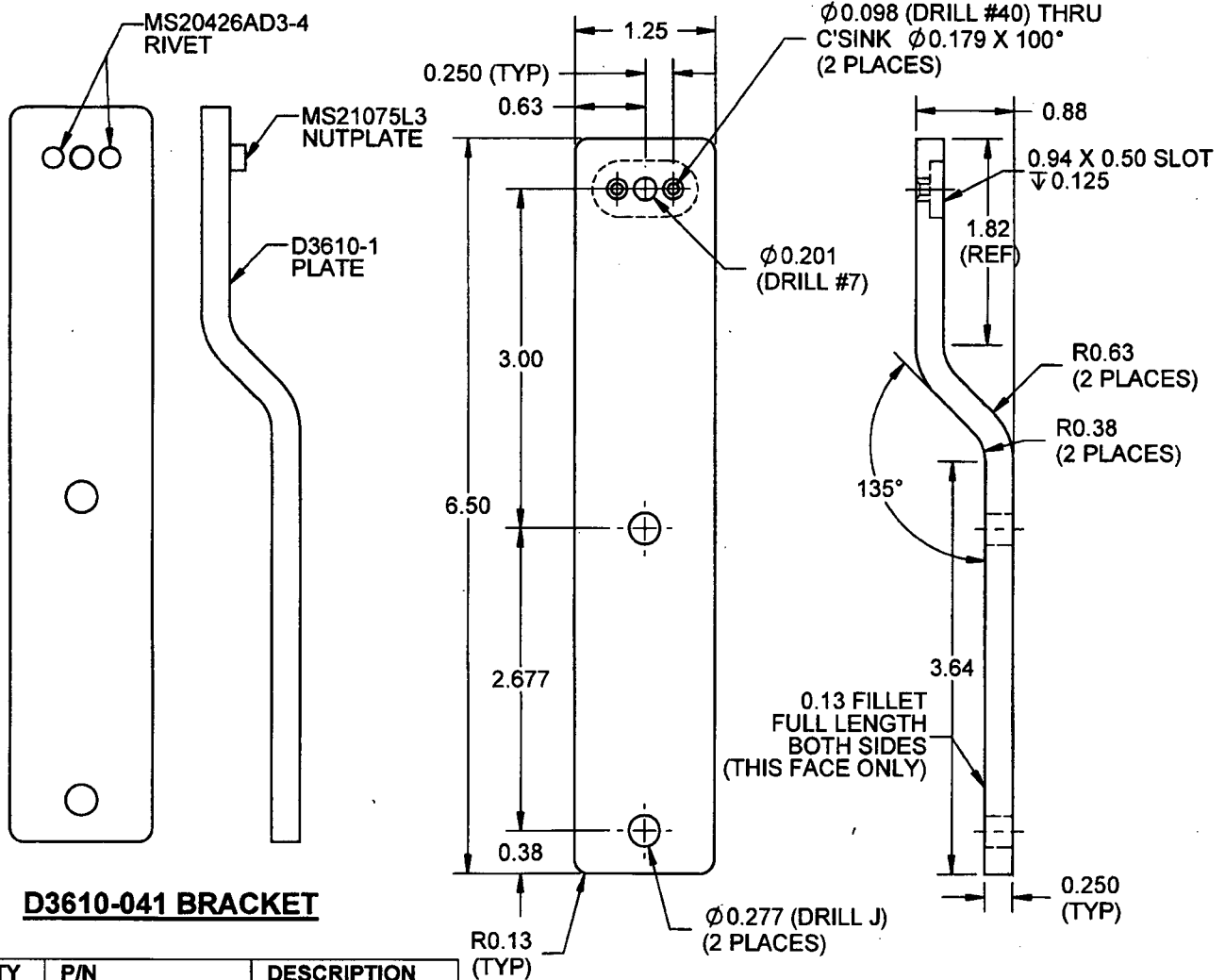
Drawing Dimension	Tolerance	Actual Dimension	Accept	Reject	Method of Inspection	Comments
1.25	+/-0.030	1.25	✓			
0.250	+/-0.010	.251	✓			
0.63	+/-0.030	.62	✓			
6.50	+/-0.030	6.50	✓			
3.00	+/-0.030	3.00	✓			
2.677	+/-0.010	2.674	✓			
0.38	+/-0.030	.38	✓			
Ø0.277	+0.006/-0.001	Ø .280	✓			
Ø0.201	+0.005/-0.001	Ø .205	✓			
Ø0.098	+0.004/-0.001	Ø .100	✓			
0.88	+/-0.030	.87	✓			
0.94 x 0.50	+/-0.030	.93 x .50	✓			
0.250	+/-0.010	.252	✓			
0.125 depth	+/-0.010	.127	✓			

Measured by:	ms	Audited by:	H.A	Prototype Approval:	N/A
Date:	09/07/03	Date:	09/09/04	Date:	N/A

Rev	Date	Change	Revised by	Approved
A	08.04.21	New Issue P/O D3610-041	KJ/DD	

DART

DESIGN <i>LE</i>	DRAWN BY <i>LE</i>	DART AEROSPACE LTD HAWKESBURY, ONTARIO, CANADA	
CHECKED <i>[Signature]</i>	APPROVED <i>[Signature]</i>	DRAWING NO. D3610	REV. A SHEET 1 OF 1
DATE 07.04.20	TITLE BRACKET		SCALE 2:3
REV A	DATE 07.04.20	DESCRIPTION NEW ISSUE	



QTY	P/N	DESCRIPTION
X	BRACKET	D3610-041
1	D3610-1	PLATE
1	MS21075L3	NUTPLATE
2	MS20426AD3-4	RIVET

RELEASED07.04.25 *[Signature]***D3610-041 NOTES:**

1) IDENTIFY WITH DART P/N "D3610-041" USING FINE POINT PERMANENT INK MARKER

D3610-1 NOTES:

- 1) MATERIAL: 4130N STEEL BAR PER MIL-S-6758 OR AMS 6348 OR 6370 OR 6528 (REF DART SPEC M4130N-B) OR 4140N STEEL BAR PER MIL-S-5626 OR AMS 6382 OR 6349 OR 6529 (REF DART SPEC M4140N-B)
- 2) FINISH: POWDER COAT GREY SANDEX (4.3.5.6) PER DART QSI 005 4.3
- 3) TOLERANCES ARE PER DART QSI 018 UNLESS OTHERWISE NOTED
- 4) ALL DIMENSIONS ARE IN INCHES UNLESS OTHERWISE NOTED
- 5) BREAK ALL SHARP EDGES 0.005 TO 0.010 MAX

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